

Date: Wednesday, 9/13/2006 4:19:28 PM
 User: Kim Johnston

Process Sheet

split
 SB 06/11/06

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PILOT/CO-PILOT STEP, LH (FOLDING)
 Job Number : 28507
 Estimate Number : 10813
 P.O. Number : NIA Part Number : D412630031
 This Issue : 9/13/2006 S.O. No. : NIA Drawing Number : D412-630 REV. J, P17
 Prsht Rev. : NC Project Number : N/A
 First Issue : NIA Type : LARGE FAB ASSY Drawing Revision : J
 Previous Run : 28152 Material : NIA
 Due Date : 10/10/2006 Qty: 3 Um: Each
 Written By : JD 06 09 14
 Checked & Approved By : JD 06 09 14
 Comment : EST. REV. A 05.11.21 NEW ISSUE EC
 EST. REV. B 05.12.19 updated pick list EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

2.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D412-630 p.17

3.0 D3463041 Step Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|---------------|--------|
| 1 | D3463-041 | Step weldment | B28175 |

4.0 D3443043 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D3443-043 | Strut ass'y | B28529 |

5.0 D3443041 Strut Weldment Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D3443-041 | Strut ass'y | B28527 |

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 28507

Part Number: D412630031

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|---------------|
| 6.0 | D34439 | PIN |
| | | |
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3443-9 Pin <u>B28166</u> | | |
| 7.0 | AN4CH3 | SS Bolt |
| | | |
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) Pick: Qty Part Number Description Batch 2 AN4CH3 BOLT <u>M19390</u> A/R MS20995c41 Lockwire <u>M101537</u> | | |
| 8.0 | AN4C14 | BOLT |
| | | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) Pick: Qty Part Number Description Batch 1 AN4C14 BOLT <u>M19096</u> | | |
| 9.0 | D34547 | Bushing |
| | | |
| Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3454-7 Bushing <u>B28170</u> | | |
| 10.0 | AN3104 | NUT |
| | | |
| Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s) Pick: Qty Part Number Description Batch 1 AN310-4 Nut <u>M19096</u> | | |

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 28507

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

MS24665227

COTTER PIN



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | MS24665-227 | COTTER PIN | M19096 |

12.0

D34551

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 2 | D3455-1 | Spacer | B28171 |

13.0

D34651

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | D3465-1 | Washer | B25536 |

14.0

AN3107

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | AN310-7 | Nut | M19096 |

15.0

MS24665302

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 1 | MS24665-302 | COTTER PIN | M16944 |

SB 06/11/07 ①

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 28507

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MA 06/11/07 (1)

17.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Pick Packing Kit

18.0

D34541

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

D3454-1

Bushing

B28167-

19.0

D34543

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3454-3

Bushing

B28168-

20.0

D34545

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

D3454-5

Bushing

B28169-

21.0

D34551

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

6

D3455-1

Spacer

B28171-

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 28507

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D34553

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 2

D3455-3

Spacer

B28172 -

23.0

D3462041

Bracket Assmly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 1

D3462-041

Bracket ass'y

B28123 -

24.0

AN3104

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 2

AN310-4

Nut

M19096 -

25.0

AN3105

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 2

AN310-5

Nut

M19096 -

26.0

AN3C5A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 3

AN3-C5A

Bolt

M122404 -

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 28507

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

AN44C12

eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 1

AN44-C12

Eyebolt

M19648-

28.0

AN4C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 1

AN4C15

BOLT

M19213-

29.0

- AN5C11

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 1

AN5C11

BOLT

M19096-

30.0

AN5C15

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

✓ 1

AN5C15

BOLT

M19213-

31.0

AN960C10

WASHER



Comment: Qty.: 7.0000 EACH(s)/Unit Total : 21.0000 EACH(s)

Pick:

Qty

Part Number

Description

Batch

✓ 7

AN960C10

Washer

M101064-

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 28507

Part Number: D412630031

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN960C516

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

AN960C516

Washer

M17697 -

33.0

MS210433

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total : 9.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

3

MS21043-3

Nut

M102407 -

34.0

MS24665227

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

MS24665-227

COTTER PIN

M102073 -

35.0

MS24665229

COTTER PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

2

MS24665-229

COTTER PIN

M19096 -

36.0

NAS1515H5

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty

Part Number

Description

Batch

1

NAS1515H5

Washer

M101064 -

26/11/08 (1)

a: Wednesday, 9/13/2006 4:19:29 PM
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Drawing Name: PILOT/CO-PILOT STEP, LH (FOLDING)

Job Number: 28507

Part Number: D412630031

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|-----|------------------------------------|
| 37.0 | QC4 | INSPECT 100% KITS FOR COMPLETENESS |
|------|-----|------------------------------------|



Comment: INSPECT 100% KITS FOR COMPLETENESS

Bog 14/08 (1)

| | | |
|------|-------------|-----------------------|
| 38.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-031

Location: _____

PPP Rev: A

Bog 11/08 (1)

| | | |
|------|------|------------------------------|
| 39.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|------|------|------------------------------|



(1)

Comment: FINAL INSPECTION/W/O RELEASE

Bog 14/08

Job Completion



4 06-16-08

376 test fit on aircraft
h

Bog 11.08 (1)

FIGURE 20 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

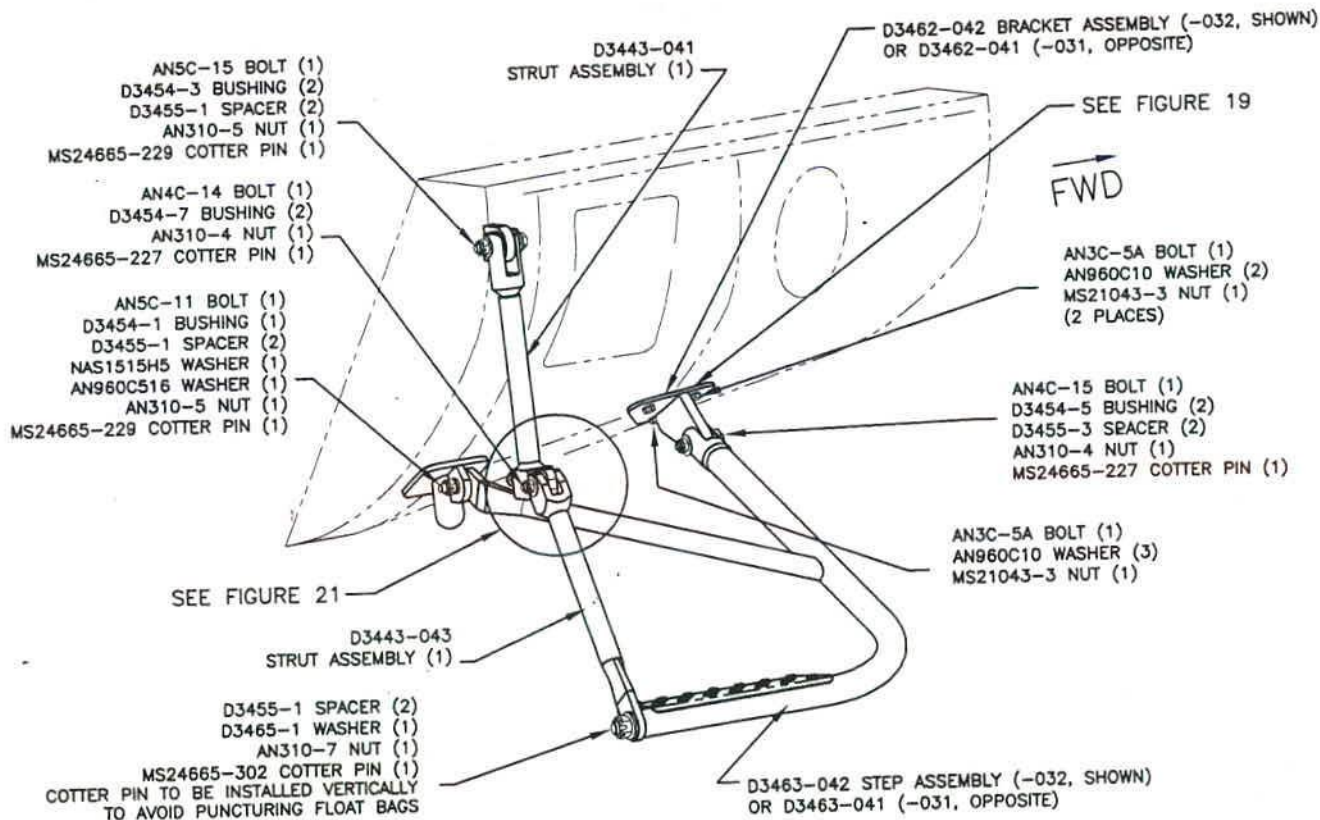
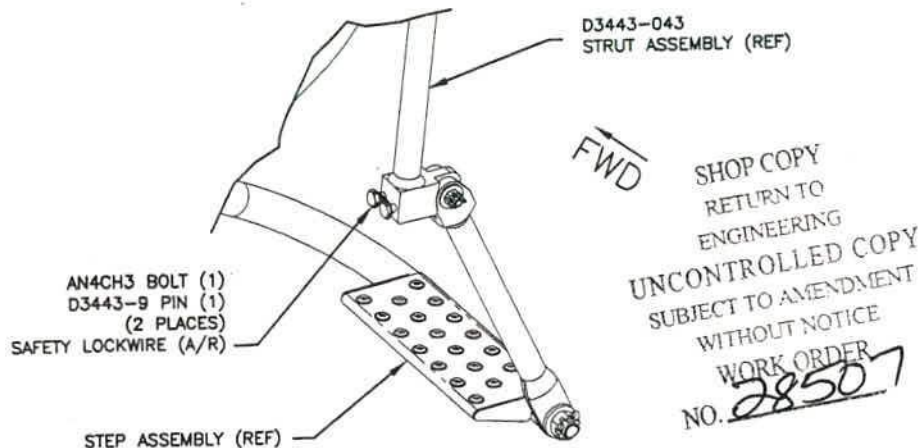


FIGURE 21 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)



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Revision: J
Date: 05.12.08